

Work Order ID 114447 - 1

Wednesday, March 05, 2014 10:23:49 AM

114447

Page 1

March

Item ID: PB67-43001-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Blade Fold Assembly

Stop *NS2*

Start Date: 3/5/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 14-3-5

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-01

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock Blue
A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK Blue batch: *M125715*
A/R touch up paint with sandflex green
batch: *M123883*

DAS
27
9-89

*1**

14-03-31

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

14/3/31

1

DAS
24
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP
RevC 10.09.24 per RevC EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

240-107

Purchased

No

100

Each

148.0000

8

16

**

DAS
32
9-89

240-107

SPRING SLOTTED PIN

Location

Loc Qty

Loc Code

ST382

148

124060

14

M127995

134

M127995

30345T22

Purchased

No

100

Each

24.0000

2

4

**

DAS
32
9-89

30345T22

8" LANYARD

Location

Loc Qty

Loc Code

ST379

24

m127014

4

m127979

20

M127014

30345T24

Purchased

No

100

Each

57.0000

2

4

**

DAS
32
9-89

14/3/12 (2)

30345T24

LANYARDS

Location

Loc Qty

Loc Code

ST380

57

M127979

57

127979

Picklist Print

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Page 2

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

AN4-10A Purchased No 100 Each

AN4-10A

Bolt

Location

Loc Qty

ST355	95
M127070	20
M127815	75

95.0000 2 4

**

DAS
32
9-89

Loc Code

M127070

AN4-13A Purchased No 100 Each

AN4-13A

Bolt

Location

Loc Qty

FG	20
122808	20
GA	14
m125709	14
ST515	894
m126193	12
m127432	36
m127817	846

928.0000 2 4

**

DAS
32
9-89

Loc Code

M127817

AN4-15A Purchased No 100 Each

AN4-15A

Bolt

Location

Loc Qty

GA	100
120449	100
ST357	250
m127817	250

350.0000 4 8

**

DAS
32
9-89

14/3/12 (2)

Loc Code

M127817

Picklist Print

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Page 3

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blac Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

AN6-11A Purchased No 100 Each
AN6-11A
 BOLT

44.0000 2 4

 DAS
 32
 9-89

Location Loc Qty
 ST339 44
 114437 19
 M127993 25

Loc Code

AN6-20A Purchased No 100 Each
AN6-20A
 BOLT

55.0000 2 4

 DAS
 32
 9-89

Location Loc Qty
 ST340 55
 M126105 25
 M127044 30

Loc Code

AN8-13A Purchased No 100 Each
AN8-13A
 Bolt

43.0000 2 4

 DAS
 32
 9-89

Location Loc Qty
 ST341 43
 123482 18
 M127993 25

Loc Code

BSP43 Purchased No 100 Each
BSP43
 RIVET

48.0000 4 8

 DAS
 32
 9-89
 14/3/12 (2)

Location Loc Qty
 ST282 48
 M127380 48

Loc Code

8-88
34
DVS

Picklist Print

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Page 4

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade-Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

CR3213-4-05 Purchased No 100 Each

296.0000 2 4
**
DAS
32
9-89

CR3213-4-05

RIVET

Location	Loc Qty
ST328	296
123301	190
m127376	106

Loc Code

D3445-041 Manufactured No 100 Each

9.0000 1 2
**
DAS
32
9-89

D3445-041

Belt Assembly

Location	Loc Qty
Mezz2	9
108356	9

Loc Code

D3447-3 Manufactured No 100 Each

19.0000 2 4
**
DAS
32
9-89

D3447-3

Square Spacer

Location	Loc Qty
Mezz2	19
103840	3
111111	16

Loc Code

D3447-7 Manufactured No 100 Each

7.0000 2 4
**
DAS
32
9-89 14/3/12 (2)

D3447-7

Clevis

Location	Loc Qty
Mezz2	7
109908	7

Loc Code

109908

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114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

D3447-9 Manufactured No 100 Each

D3447-9

Swing Arm

9.0000 2 4
**
DAS
32
9-89

Location Loc Qty

Mezz2 9
110604 9

Loc Code

D3451-041 Manufactured No 100 Each

D3451-041

Handle And Lock-Down Assembly

9.0000 1 2
**
DAS
32
9-89

Location Loc Qty

Mezz2 9
104490 1
111741 5
111742 3

Loc Code

D3451-047 Manufactured No 100 Each

D3451-047

Handle And Lock-Down Assembly

9.0000 1 2
**
DAS
32
9-89

Location Loc Qty

Mezz2 9
104630 1
111747 3
111748 5

Loc Code

D3922-1 Manufactured No 100 Each

D3922-1

Clip

107.0000 2 4
**
DAS
32
9-89

Location Loc Qty

ST072 107
111733 100
66852 7

Loc Code

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

MS17984-C408

Purchased

No

100

Each

MS17984-C408

PIN, QUICK RELEASE

Location

Loc Qty

ST332	39
m126872	9
m127376	10
m128051	20

MS17984-C418

Purchased

No

100

Each

MS17984-C418

PIN, QUICK RELEASE

Location

Loc Qty

FG	1
123482	1
ST332	43
m126872	2
m127255	1
m127993	40

MS21042L3

Purchased

No

100

Each

MS21042L3

Nut

Location

Loc Qty

ST314	2614
M127410	2573
M127831	41
ST506	955
123900	955

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

39.0000 2 4

**

DAS
32
9-89

Loc Code

m126872

44.0000 2 4

**

DAS
32
9-89

Loc Code

m127993

3,569.000 2 4

**

DAS
32
9-89

14/3/12 (2)

Loc Code

m127410

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Berding ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strap in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

MS21042L4 Purchased No 100 Each

5,807.000 8 16

MS21042L 4

Locknut

DAS
32
9-89

Location Loc Qty

Loc Code

ST314	32
m126275	32
ST509	5764
m127255	816
m127813	1948
m128300	3000
ST518	11
m127376	11

m127205

MS21042L6 Purchased No 100 Each

217.0000 4 8

MS21042L 6

Nut

DAS
32
9-89

Location Loc Qty

Loc Code

ST314	217
m127304	2
m127831	26
m127904	189

m127904

MS27039-1-04 Purchased No 100 Each

200.0000 2 4

MS27039-1-04

Screw

DAS
32
9-89 14/3/12 @

Location Loc Qty

Loc Code

ST305	200
124555	190
m128228	10

m124555

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of-Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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114447

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-21

Purchased

No

100

Each

622.0000

2

4

DAS
32
9-89

MS27039-1-21

Screw

Location

Loc Qty

ST506

622

124326

122

m126319

100

m127904

400

Loc Code

**

124326

MS51859-6

Purchased

No

100

Each

113.0000

4

8

DAS
32
9-89

MS51859-6

WASHER

Location

Loc Qty

ST290

113

123482

63

m126474

50

Loc Code

**

m123482

MS51859-7

Purchased

No

Each

111.0000

8

8

DAS
32
9-89

MS51859-7

Washer

Location

Loc Qty

ST290

111

123482

15

M127993

96

Loc Code

**

123482 32
m127993 50

MS51859-8

Purchased

No

100

Each

194.0000

8

16

DAS
32
9-89

MS51859-8

Washer

Location

Loc Qty

ST290

194

m127993

194

Loc Code

**

m127993

14/3/12 (2)

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 9

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J

Purchased

No

100

Each

186.0000

6

12

NAS1149DN632J

Washer

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST293

186

M126084

86

M127255

100

M126084

NAS1149F0316P

Purchased

No

100

Each

110.0000

4

8

NAS1149F0316P

WASHER

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST295

110

113237

10

113644

100

113237

NAS1149F0432P

Purchased

No

100

Each

814.0000

16

32

NAS1149F0432P

WASHER

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST295

750

M127813

750

ST510a

64

M126221

64

M127813

NAS1149F0632P

Purchased

No

100

Each

233.0000

8

16

NAS1149F0632P

WASHER

**

DAS
32
9-89

14/3/12

Location

Loc Qty

Loc Code

ST295

233

18057

233

18057

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Shop Packet Print

Page 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

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Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Wednesday, March 05, 2014 10:23:48 AM

Page 10

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0832P

Purchased

No

100

Each

213.0000

2

4

NAS1149F0832P

WASHER

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST295

213

18057

213

18057

NAS43DD3-68

Purchased

No

100

Each

51.0000

2

4

NAS43DD3-68

Spacer

**

DAS
32
9-89

14/3/12

Location

Loc Qty

Loc Code

ST275

51

124330

51

124330

PB67-43001-07

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-07

Fwd Blade Fold Assembly Weldment

**

B114050 → ②

DAS
24
9-89

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-11

Fwd Adjustable Blade Support Assembly

**

B113006 → ②

DAS
24
9-89

PB67-43001-15

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-15

Fwd Adjustable Blade Support Assembly

**

B113234 → ②

DAS
24
9-89

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-21

Upper Blade Support And Cover Assembly

**

B112988 → ②

DAS
24
9-89

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-23

Lower Blade Support And Cover Assembly

**

B113402 → ②

DAS
24
9-89

Wednesday, March 05, 2014 10:23:48 AM

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Page 10

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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 11

Work Order ID: 114447

114447

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-261 Manufactured No 100 Each

PR67-43001-261

Lever Arm

34.0000 2 4

**

DAS
32
9-89

Location

Loc Qty

Loc Code

Mezz2

34

111102

16

113388

18

79.0000 4 8

**

DAS
32
9-89

113388

PB67-43001-265 Manufactured No 100 Each

PR67-43001-265

Deltin Bushing

Location

Loc Qty

Loc Code

Mezz2

79

111103

20

113389

40

99967

19

53.0000 2 4

**

DAS
32
9-89

99967

PB67-43001-299 Manufactured No 100 Each

PR67-43001-299

Bushing

Location

Loc Qty

Loc Code

Mezz2

53

113390

30

99957

23

0.0000 1 2

**

DAS
24
9-89

99957

PB67-43001-45 Manufactured No 100 Each

PR67-43001-45

Longitudinal Support

PB67-43001-51 Manufactured No 100 Each

PR67-43001-51

Long T-Handle Assembly

0.0000 1 2

**

DAS
24
9-89

B113393 → ②

B113392 → ②

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Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

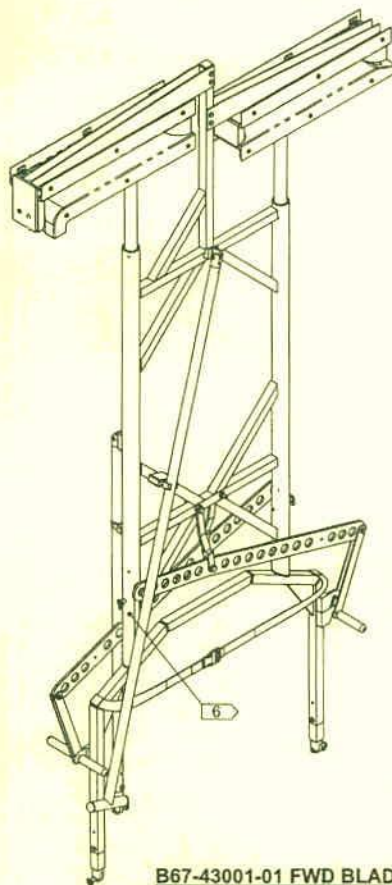
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELTRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP#13	RIVET
27	2	CR32/13-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS1859-6	NYLON WASHER
37	4	MS1859-7	NYLON WASHER
38	8	MS1859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242TX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011)	VS	10.06.11
REV	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	VS	B67-43001-01	SHEET 1 OF 2
APPROVED	VS	TITLE	SCALE
DE APPR.	VS	FWD BLADE FOLD ASSY	NTS
DATE	10.06.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

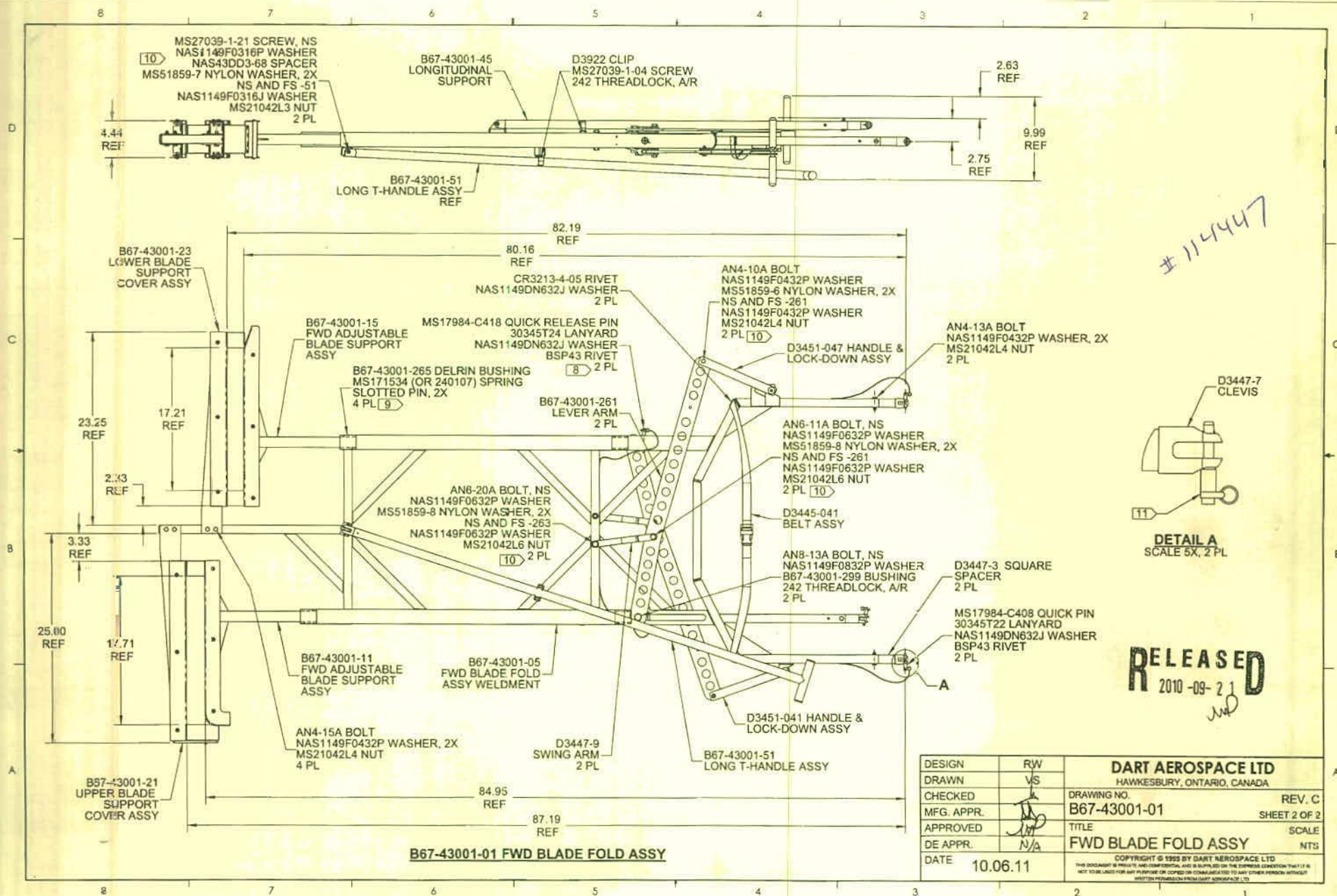
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-01	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY	NTS
DATE	10.06.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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